

ASAP

Monday, 10/03/2009 11:27:45 AM
a Lacelle

Process Sheet

Job Number	: CU-DAR001 Dart Helicopters Services	Drawing Name	: WEARPLATE ASSEMBLY
Estimate Number	: 46395	Part Number	: D3805045
P.O. Number	:	Drawing Number	: D3805 REV.A
This Issue	: 10/03/2009 S.O. No. :	Project Number	: N/A
Prsht Rev.	: NC	Drawing Revision	: A
First Issue	: / / Type : LARGE FAB ASSY	Material	:
Previous Run	: 05054	Due Date	: 18/03/2009 Qty: 2 Um: Each
Written By	: <u>W</u>		
Checked & Approved By	: <u>W</u>		
Comment	Est Rev:A 08-12-01 new issue EC verified by:DD Est Rev:B 09-03-04 rev.a as per dwg DD verified by:EC		

12 test

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D38055	Plate
-----	--------	-------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Plate

Batch: B46396

EL 9-3-12

2.0	D38065	Bar
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bar

batch: B46397

EL 9-3-12

3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

1- on D3806-5 , fill cut outs with hardcoat welding rod as per dwg D3805

2059 B Hardcoat Welding Rod

BATCH#: M11036

2-weld D3806-5 to wearplate by positioning holes together as per dwg D3805

304 S.S. Welding Rod

BATCH #: M106115

EL 9-3-13 18

4.0	QC9	VISUAL WELDING INSPECTION
-----	-----	---------------------------



Comment: VISUAL WELDING INSPECTION

QC09.03.16

(x2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3805-045 PAR #: N/A Fault Category: Prod / FAB.assy med & small NCR: Yes No DQA: + Date: 09/03/20
 Resolution: SCRAP Disposition: SCRAP QA: N/C Closed: D Date: 09/03/20

NCR: <u>46395</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
090313	3.0	1x D3806-5 B46393 was scraped during welding. The hand facing burned through the material on 1 side. Material was 0.015" thinner than the other, from w.j. cutting taper Q.C. process. Q.C. passed the part under the assumption that all the weld would be okay, considering the min. mat'l thickness on the D3806-5 is thicker than a normal wear plate.	<u>BS1412</u>	Scrap: destroy 1 & replace B <u>46479</u> was created.	<u>EL</u> <u>9.3/16</u>	<u>S</u> <u>09/03/20</u>	<u>BS1412</u>	<u>090313</u>
	3.0		<u>BS1412</u>		<u>EL</u> <u>9.3/16</u>	<u>S</u> <u>09/03/20</u>	<u>BS1412</u>	<u>090313</u>

NOTE: Date & initial all entries

Date: Tuesday, 10/03/2009 11:27:45 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE ASSEMBLY

Job Number: 46395

Part Number: D3805045

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/03/16 (X2)

6.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

(X2)

START TIME:

8:25

OVEN TEMPERATURE:

320°

FINISH TIME:

8:55

UMD/FL

09/03/17

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-03-17

(X2)

8.0

D38075

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Gasket

batch: B 46401

S 09/03/17

9.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Scuff with 150 grit sand paper 9/3/17

1- Bond D3807-5 gasket to inner surface of wearplate using Scotch-grip adhesive.

A/R Scotch-grip batch: M109410

FF 09-03-19

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/03/19 (X2)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with Dart part # using a fine point permanent marker and Stock

Location: _____

w/o 46375A01

W

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Date: Tuesday, 10/03/2009 11:27:45 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE ASSEMBLY

Job Number: 46395

Part Number: D3805045

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC21

FINAL INSPECTION/W/O RELEASE



09/03/19 JJ

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W 09/03/19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

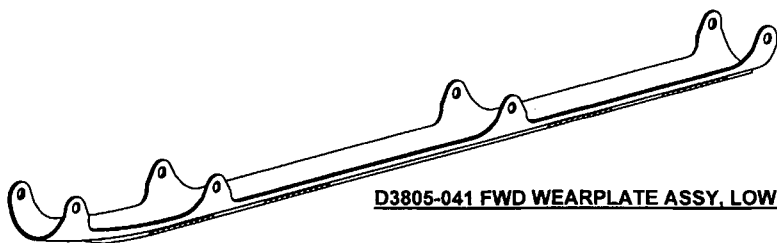
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

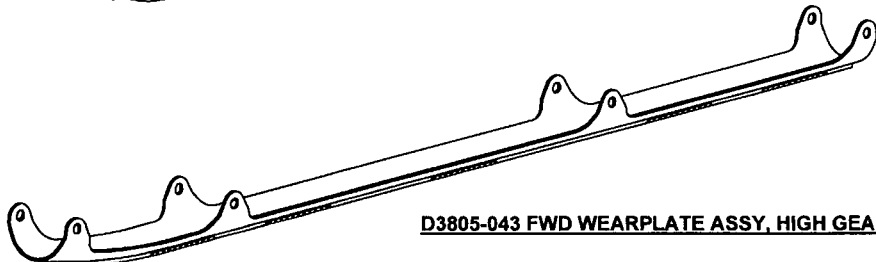
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

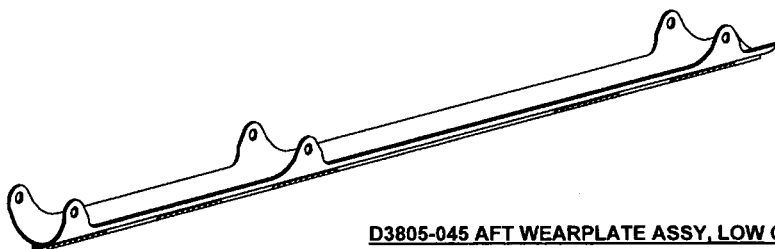
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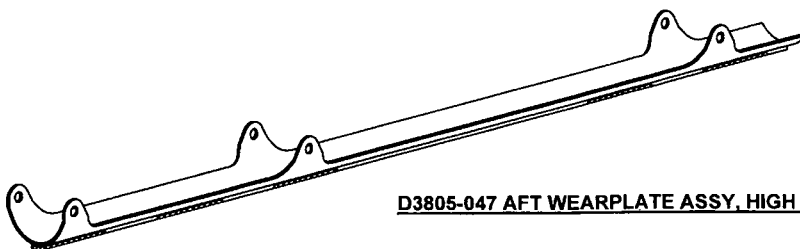
D3805-041 FWD WEARPLATE ASSY, LOW GEAR



D3805-043 FWD WEARPLATE ASSY, HIGH GEAR



D3805-045 AFT WEARPLATE ASSY, LOW GEAR



D3805-047 AFT WEARPLATE ASSY, HIGH GEAR

Handwritten: 140416395

ITEM	QTY -041	QTY -043	QTY -045	QTY -047	P/N	DESCRIPTION
1	X				D3805-041	FWD WEARPLATE ASSY, LOW GEAR
2		X			D3805-043	FWD WEARPLATE ASSY, HIGH GEAR
3			X		D3805-045	AFT WEARPLATE ASSY, LOW GEAR
4				X	D3805-047	AFT WEARPLATE ASSY, HIGH GEAR
11	1				D3805-1	PLATE
12		1			D3805-3	PLATE
13			1		D3805-5	PLATE
14				1	D3805-7	PLATE
15	1				D3806-1	BAR
16		1			D3806-3	BAR
17			1		D3806-5	BAR
18				1	D3806-7	BAR
19	1				D3807-1	GASKET
20		1			D3807-3	GASKET
21			1		D3807-5	GASKET
22				1	D3807-7	GASKET
31	A/R	A/R	A/R	A/R	2059B	HARDCOAT
32	A/R	A/R	A/R	A/R	1300 (OR 1300L)	3M SCOTCH-GRIP ADHESIVE

RELEASED
Handwritten: 07-03-03
Handwritten: PER ECN 07-538

A	NEW ISSUE	MB	08.11.21
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>Handwritten:</i> 140416395	DART AEROSPACE USA, INC.	
DRAWN	<i>Handwritten:</i> 140416395	PORT HADLOCK, WA	
CHECKED	<i>Handwritten:</i> 140416395	DRAWING NO.	REV. A
MFG. APPR.	<i>Handwritten:</i> 140416395	D3805	SHEET 1 OF 8
APPROVED	<i>Handwritten:</i> 140416395	TITLE	SCALE
DE APPR.	<i>Handwritten:</i> 140416395	WEARPLATE ASSY	NTS
DATE	08.11.21	<small>COPYRIGHT © 2008 BY DART AEROSPACE USA, INC.</small> <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

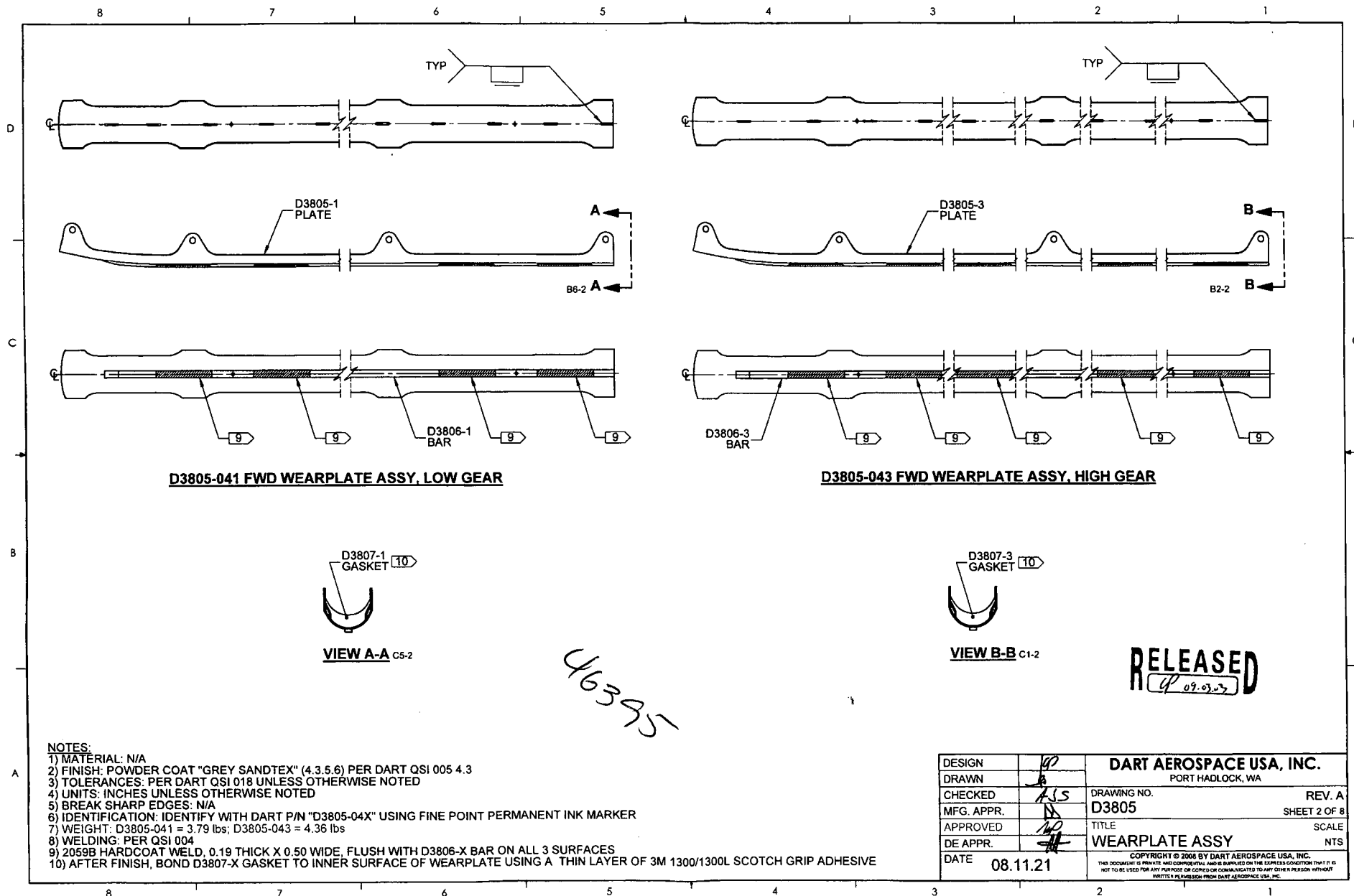
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "GREY SANDEXT" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3805-04X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: D3805-041 = 3.79 lbs; D3805-043 = 4.36 lbs
- 8) WELDING: PER QSI 004
- 9) 2059B HARDCOAT WELD, 0.19 THICK X 0.50 WIDE, FLUSH WITH D3806-X BAR ON ALL 3 SURFACES
- 10) AFTER FINISH, BOND D3807-X GASKET TO INNER SURFACE OF WEARPLATE USING A THIN LAYER OF 3M 1300/1300L SCOTCH GRIP ADHESIVE

DESIGN	<i>JP</i>	DART AEROSPACE USA, INC.	
DRAWN	<i>JP</i>	PORT HADLOCK, WA	
CHECKED	<i>LS</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>LS</i>	D3805	SHEET 2 OF 8
APPROVED	<i>LS</i>	TITLE	SCALE
DE APPR.	<i>LS</i>	WEARPLATE ASSY	NTS
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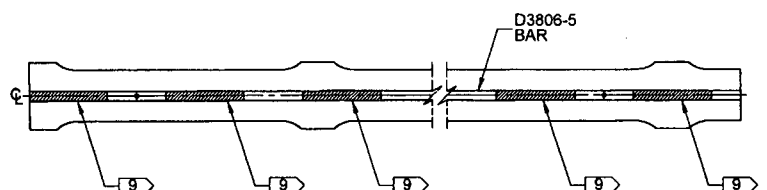
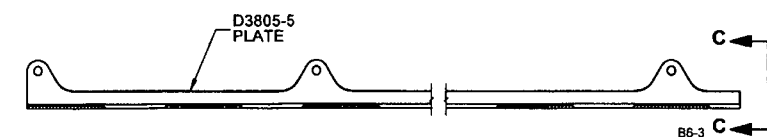
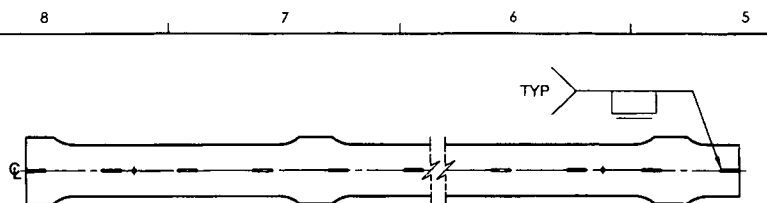
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

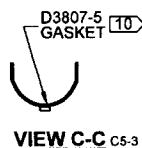
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

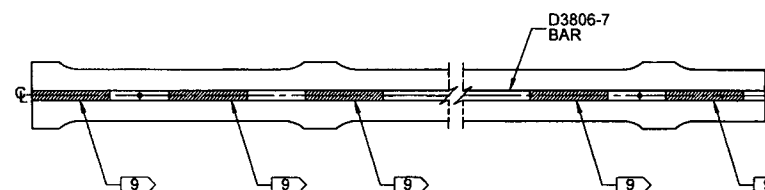
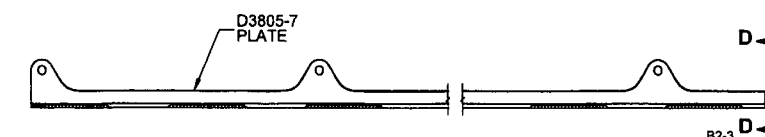
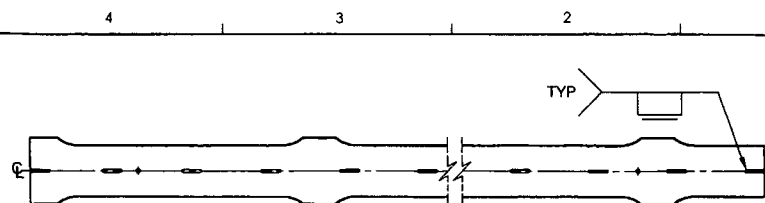


D3805-045 AFT WEARPLATE ASSY.

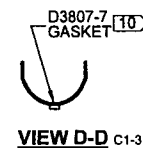


VIEW C-C C5-3

46395



D3805-047 AFT WEARPLATE ASSY.



VIEW D-D C1-3

RELEASED
09.03.07

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "GREY SANDEXT" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3805-04X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: D3805-045 = 3.93 lbs; D3805-047 = 4.21 lbs
- 8) WELDING: PER QSI 004
- 9) 2059B HARDCOAT WELD, 0.19 THICK X 0.50 WIDE, FLUSH WITH D3806-X BAR ON ALL 3 SURFACES
- 10) AFTER FINISH, BOND D3807-X GASKET TO INNER SURFACE OF WEARPLATE USING A THIN LAYER OF 3M 1300/1300L SCOTCH GRIP ADHESIVE

DESIGN	197	DART AEROSPACE USA, INC.	
DRAWN	197	PORT HADLOCK, WA	
CHECKED	197	DRAWING NO.	REV. A
MFG. APPR.	197	D3805	SHEET 3 OF 8
APPROVED	197	TITLE	SCALE
DE APPR.	197	WEARPLATE ASSY	
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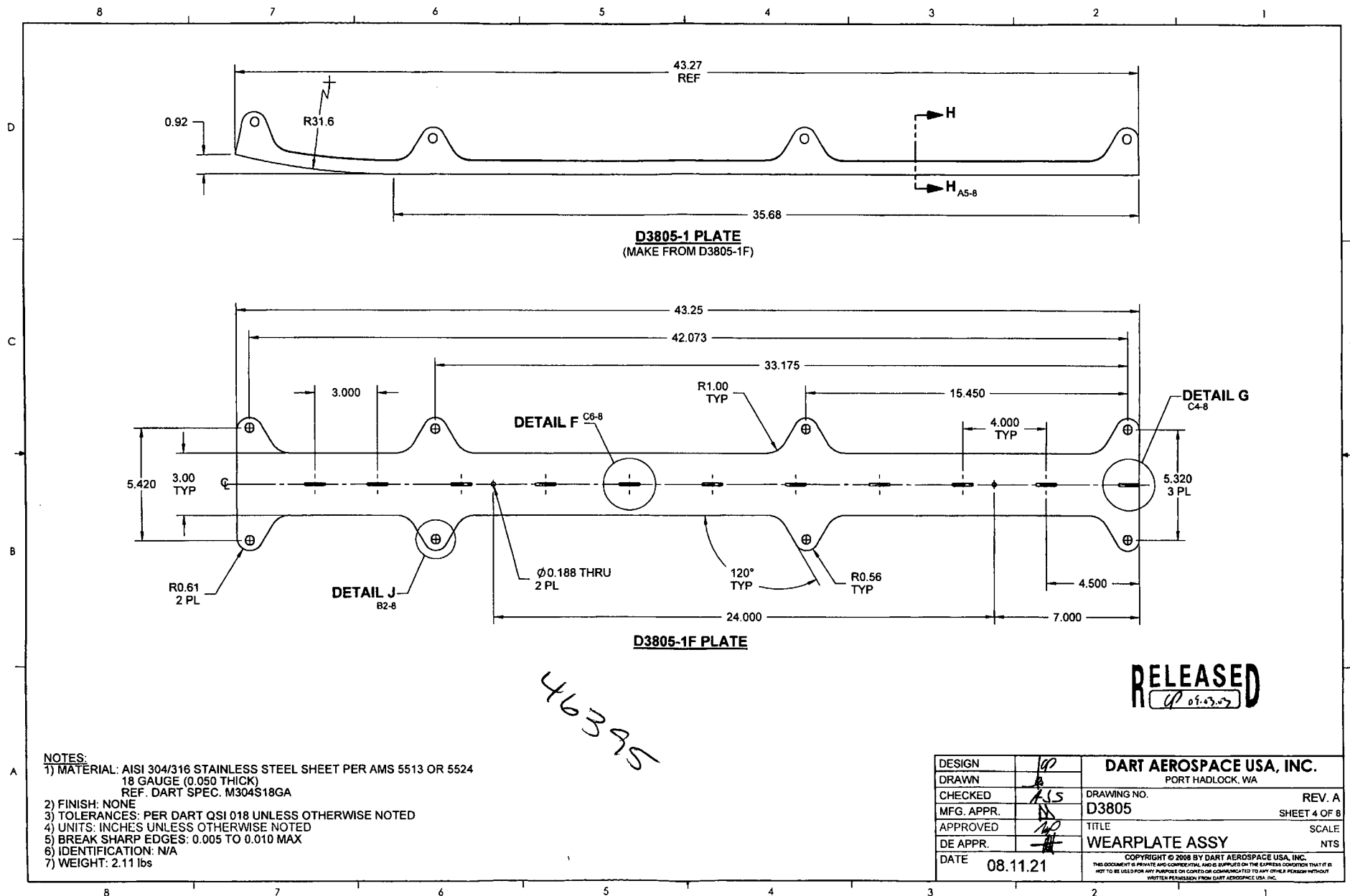
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



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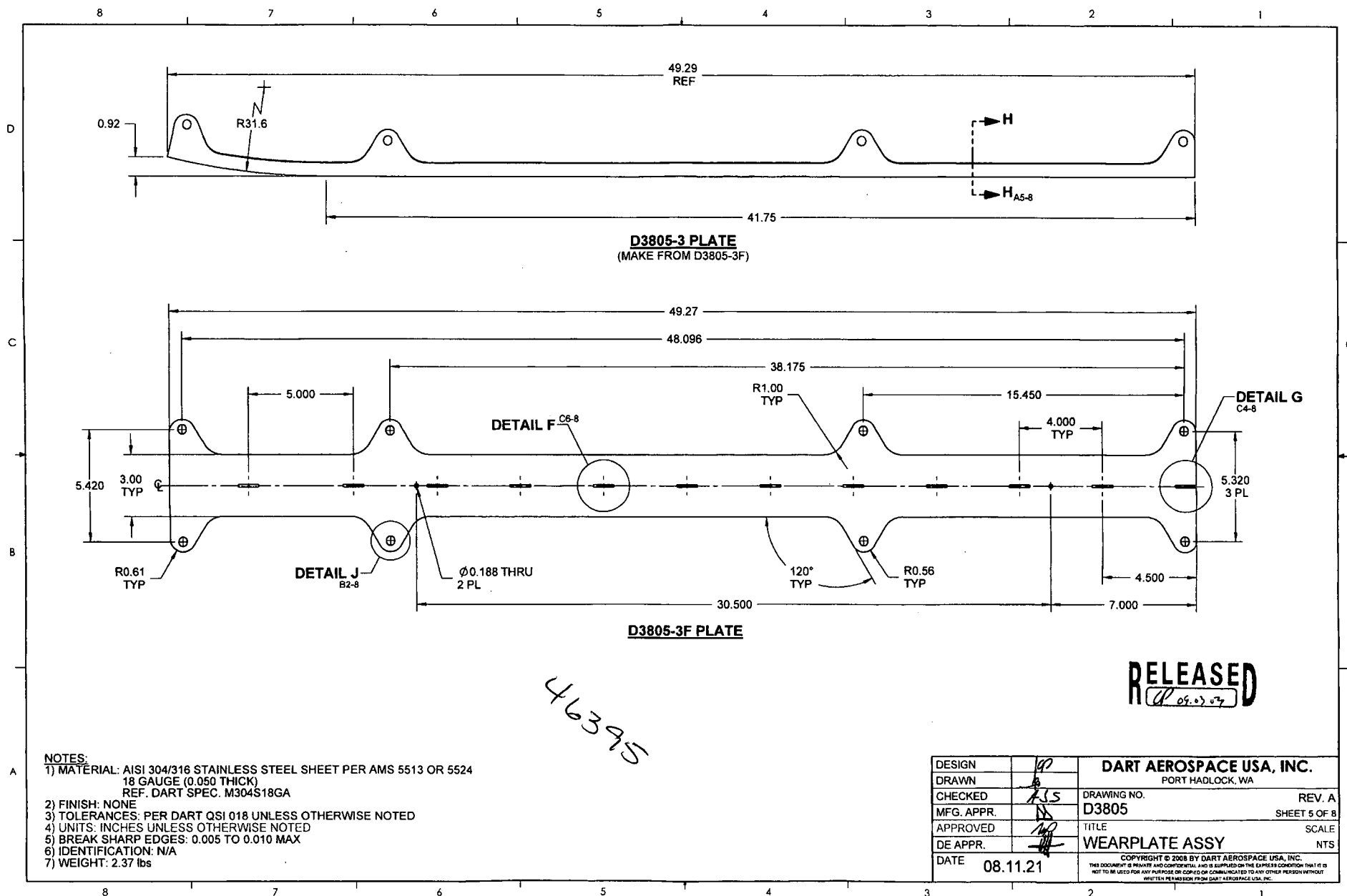
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

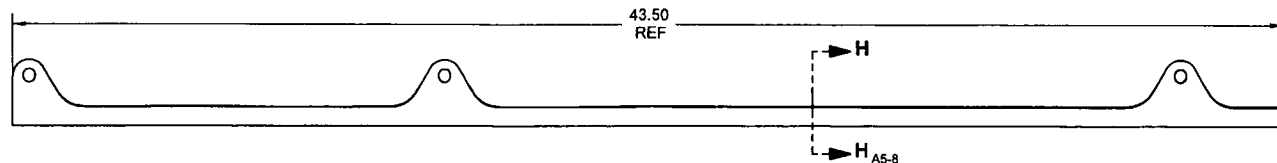
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

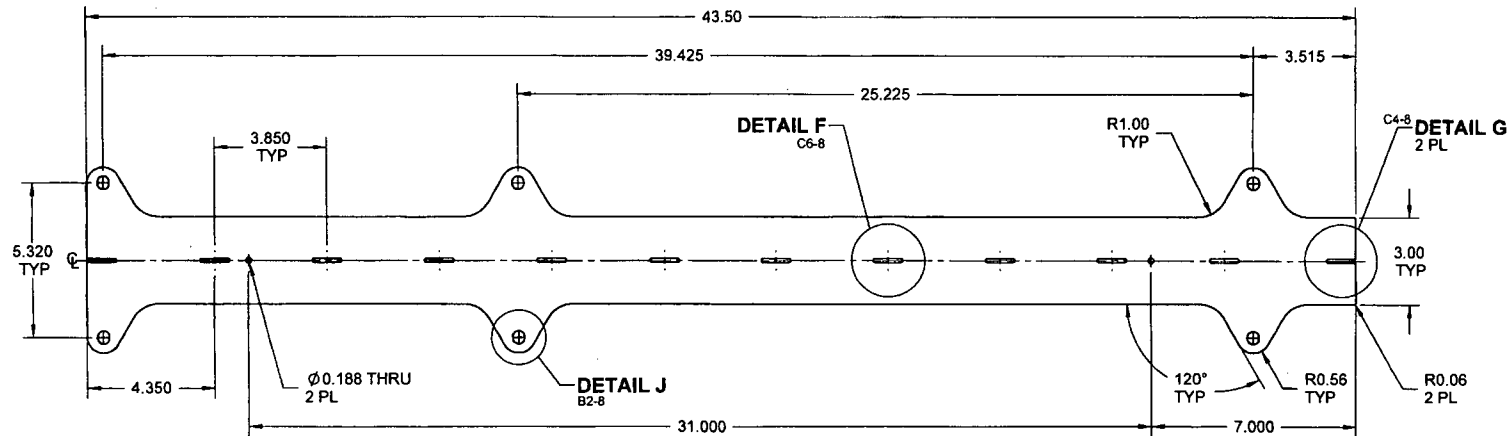
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



D3805-5 PLATE
(MAKE FROM D3805-SF)



D3805-SF PLATE

RELEASED
47 09 03 03

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
18 GAUGE (0.050 THICK)
REF. DART SPEC. M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.06 lbs

46395

DESIGN	10	DART AEROSPACE USA, INC.	
DRAWN	10	PORT HADLOCK, WA	
CHECKED	10	DRAWING NO.	REV. A
MFG. APPR.	10	D3805	SHEET 6 OF 8
APPROVED	10	TITLE	SCALE
DE APPR.	10	WEARPLATE ASSY	NTS
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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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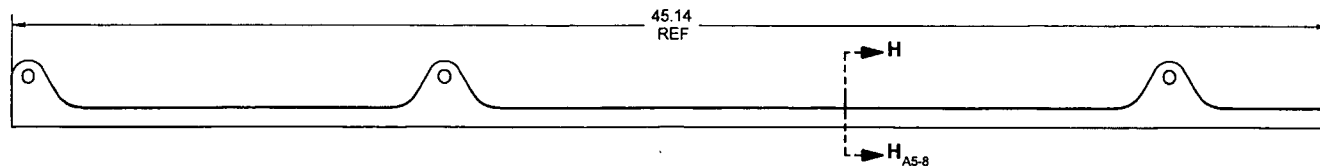
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

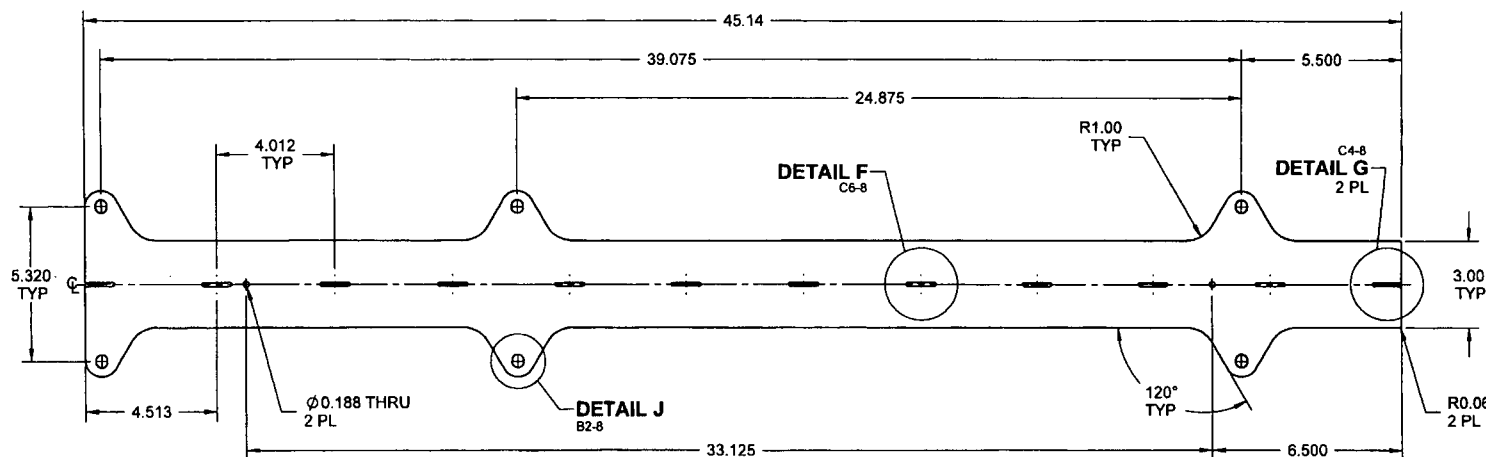
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



D3805-7 PLATE
(MAKE FROM D3805-7F)



D3805-7F PLATE

RELEASED
46395

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
18 GAUGE (0.050 THICK)
REF. DART SPEC. M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.13 lbs

DESIGN	46395	DART AEROSPACE USA, INC.	
DRAWN	ALS	PORT HADLOCK, WA	
CHECKED	ALS	DRAWING NO.	REV. A
MFG. APPR.	ALS	D3805	SHEET 7 OF 8
APPROVED	ALS	TITLE	SCALE
DE APPR.	ALS	WEARPLATE ASSY	NTS
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8 7 6 5 4 3 2 1

Dart Aerospace Ltd

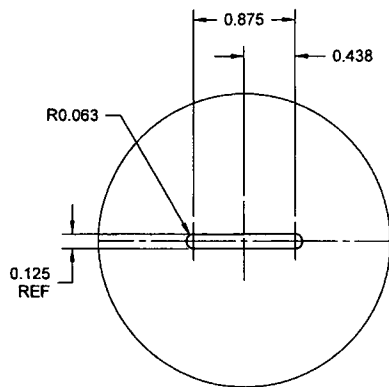
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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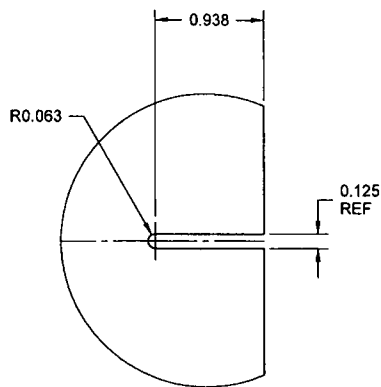
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



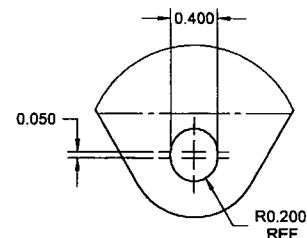
DETAIL F
SLOT DETAIL TYP
SCALE 4X

C5-4
C5-5
C4-6
C4-7



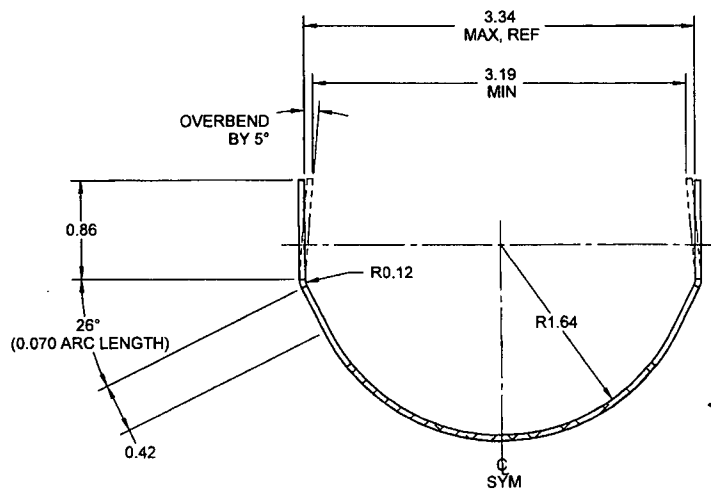
DETAIL G
SLOT DETAIL TYP
SCALE 4X

C1-4
C1-5
C1-6
C2-7



DETAIL J
SCALE 4X

B6-4
B7-5
B5-6
B5-7



SECTION H-H
SCALE 4X

D3-4
D3-5
D3-6
D3-7

46395

RELEASED
4709.03.03

DESIGN	197	DART AEROSPACE USA, INC.	
DRAWN	JS	PORT HADLOCK, WA	
CHECKED	JS	DRAWING NO.	REV. A
MFG. APPR.	JS	D3805	SHEET 8 OF 8
APPROVED	JS	TITLE	SCALE
DE APPR.	JS	WEARPLATE ASSY	NTS
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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries